

Work Order ID 75040

75040

Page 1

October-17-11 10:31:16 AM

Item ID: D3535-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 17/10/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 27/10/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
 304.046 Deburr if necessary B11-10-28 B11-10-26 (12)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control B11-10-26

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control Sukolze (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT83262- Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25	0.00 0.00				(12)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							W/ 11 - 11 - 01 (12)
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:45 FINISH TIME: 4:15	0.00 0.00							12x Ø M/L 11/11/01

M 118435

3200F

4:15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	BR	11-11-2	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-1</u> Memo	0.00 0.00				12	BR	11-11-2	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/11/02 (P)

11-11-02
(P)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:31:21 AM

Page 1

Work Order ID: 75040

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Parent Item: D3535-25

D3535-25

Parent Item Name: Wearshoe

Start Date: 17/10/2011

Required Date: 27/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.51	6.442105			

M304S20GA

304/316 .040 Sheet

131-10

Location

Loc Qty

Loc Code

MAT020

137.0795

116623

0.2

117550

8.363

117933

43.3442

118400

25.6723

118964

59.5

119346

119346

12

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W/O:		WORK ORDER CHANGES					
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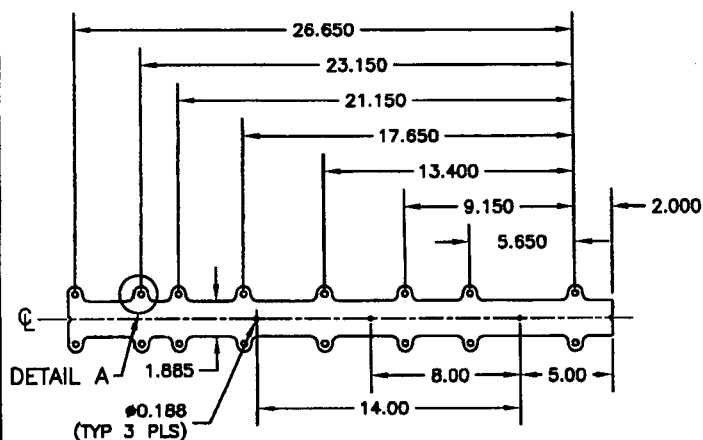
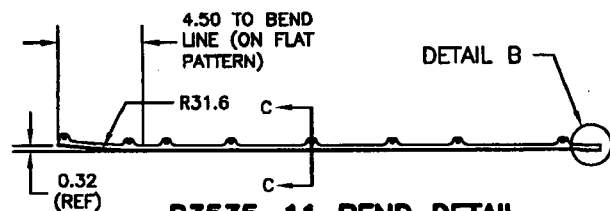
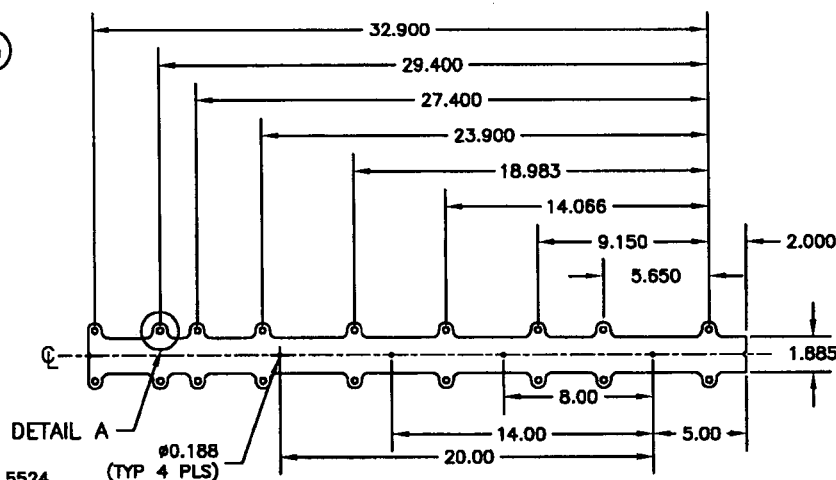
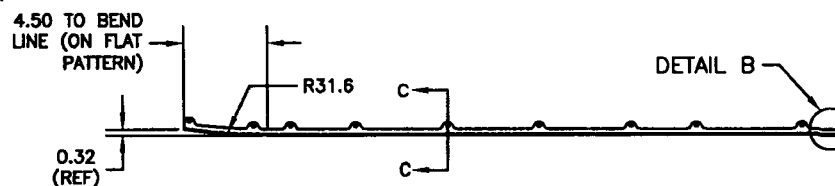
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07.04.24

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75040

11-10-17**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SCALE
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A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

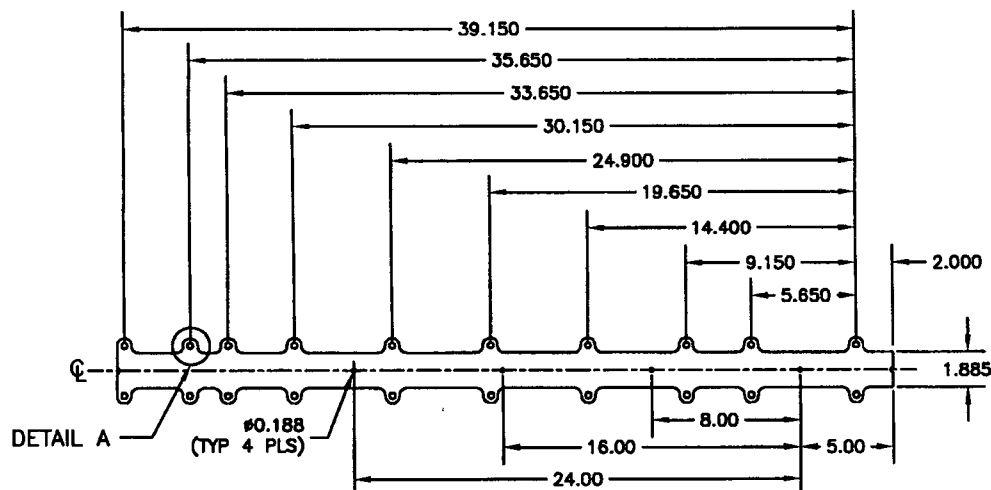
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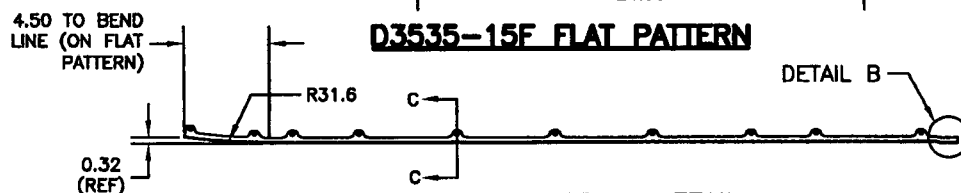
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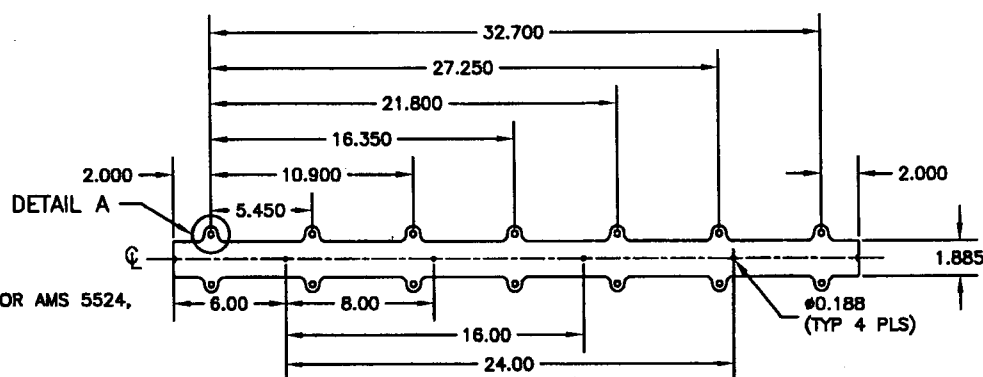
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CB	PH	PORT HADLOCK, WA	REV. B
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		D3535	SCALE
DATE	TITLE	WEARSHOE	1:10
07.04.17			



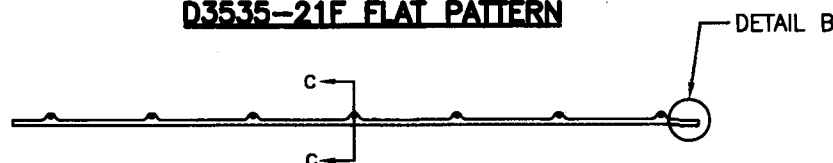
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

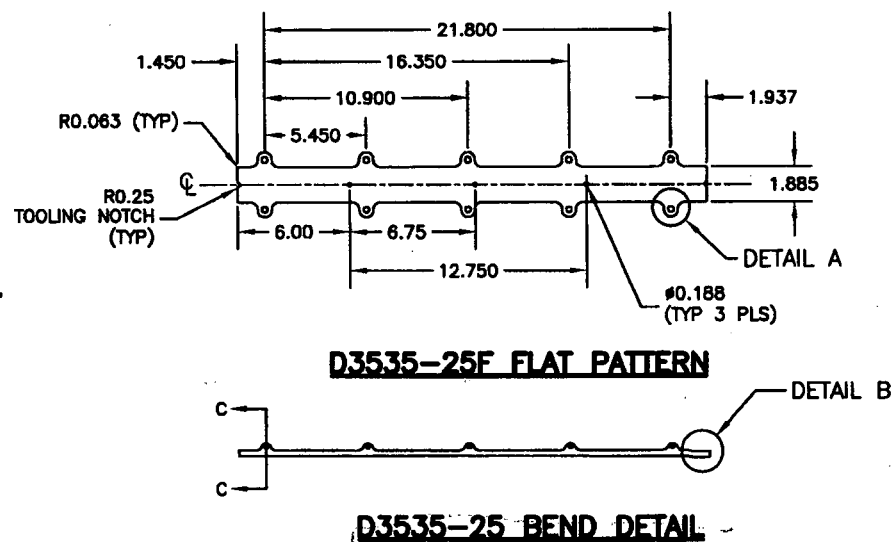
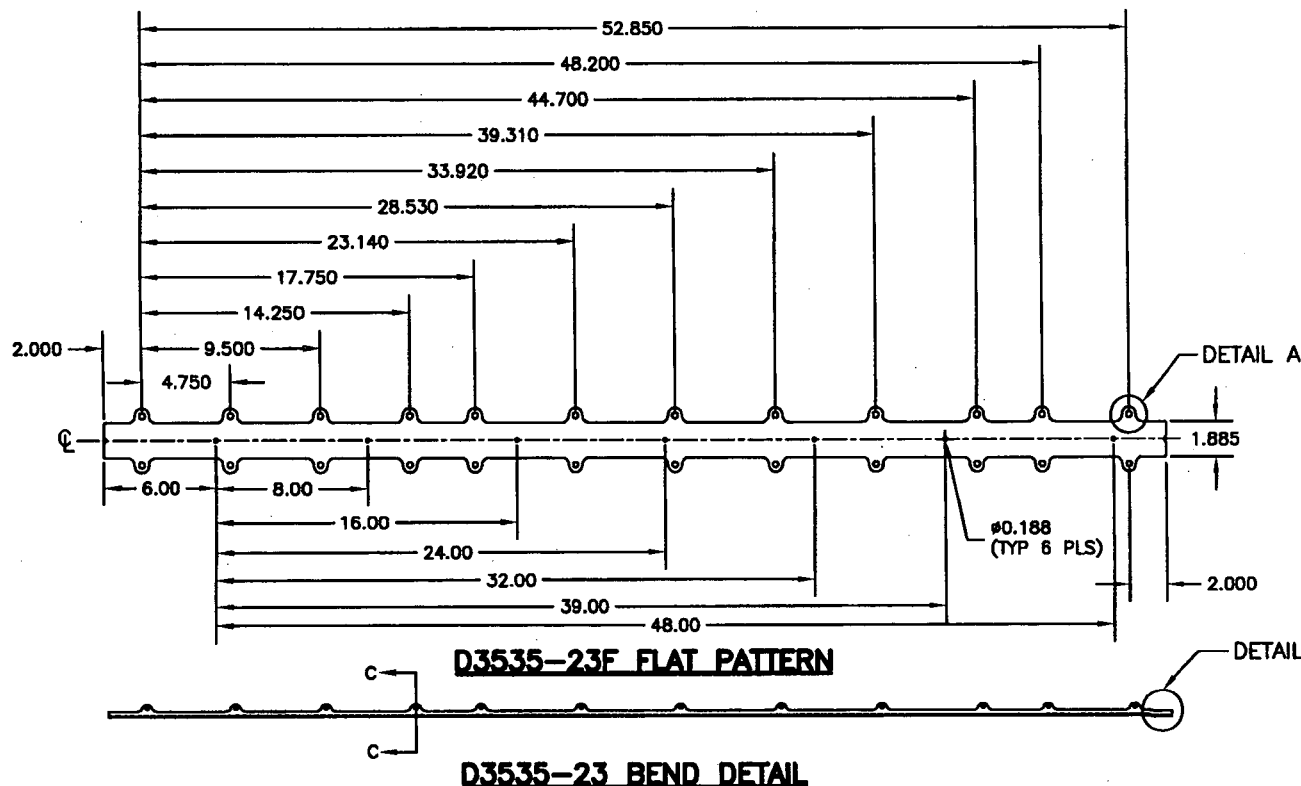
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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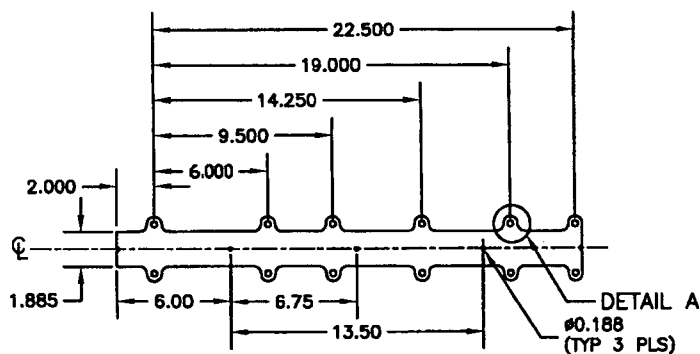
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DATE	TITLE	SCALE	
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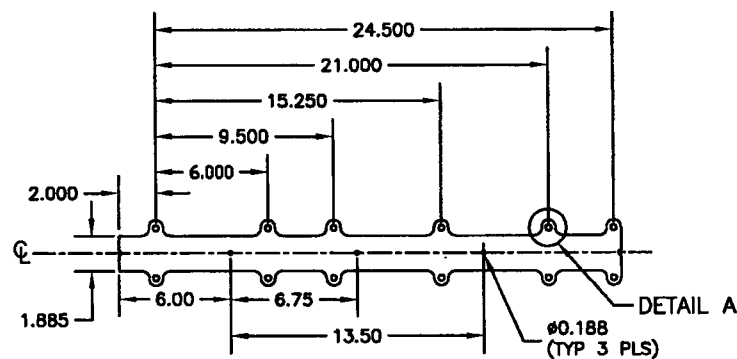
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

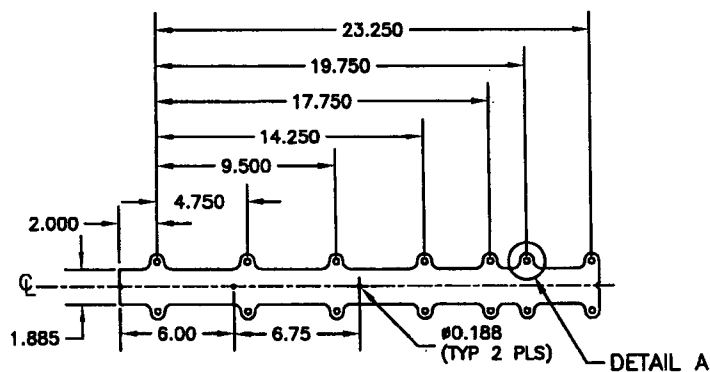
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DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

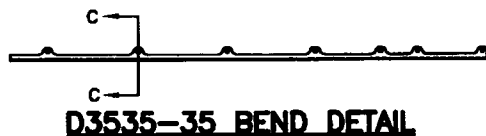
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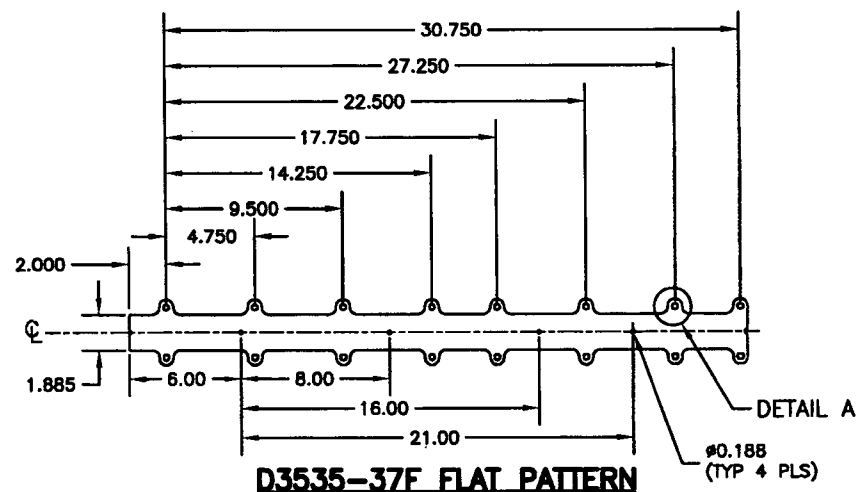
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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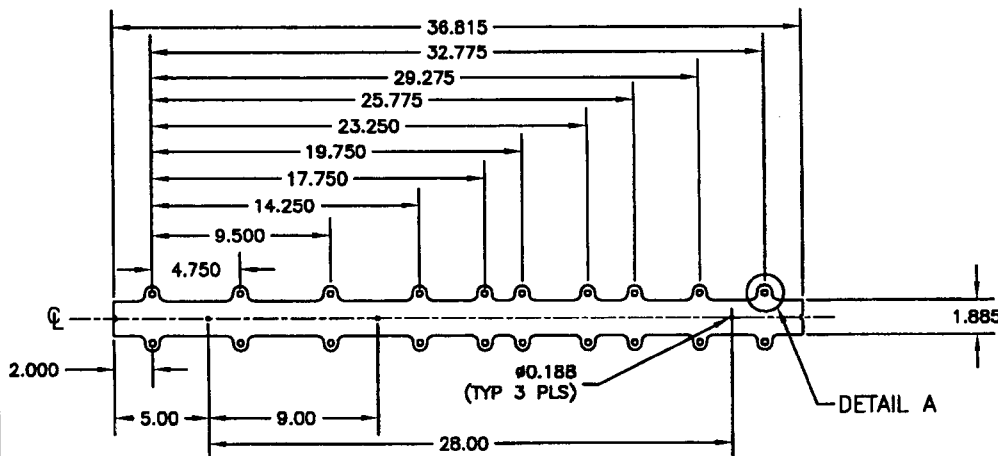
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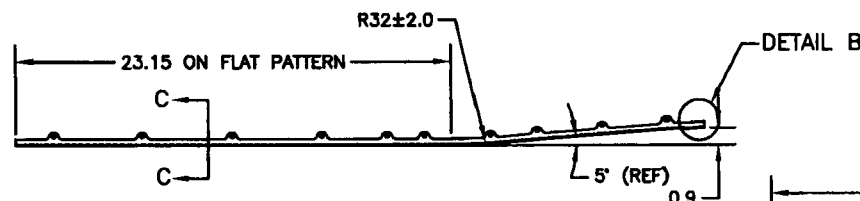
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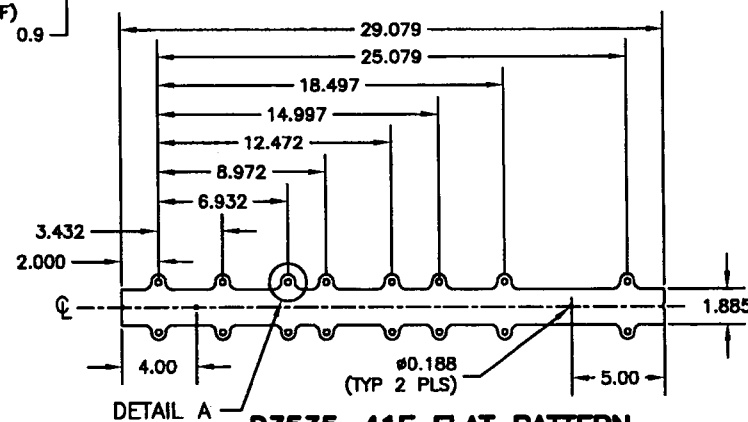
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TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
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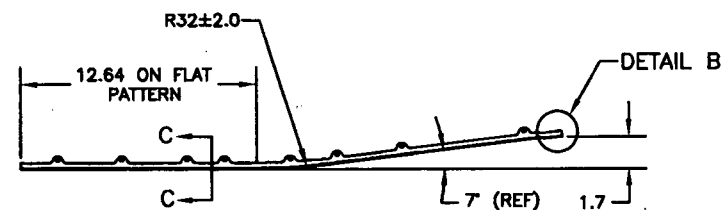
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



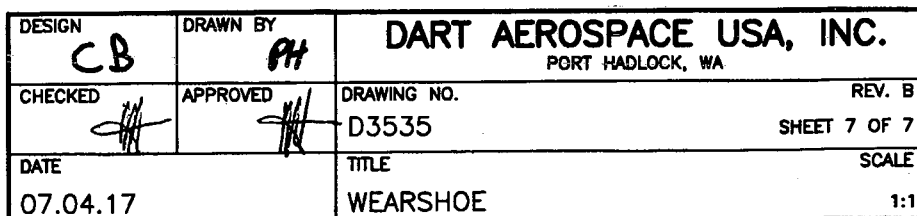
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D3535-41 BEND DETAIL

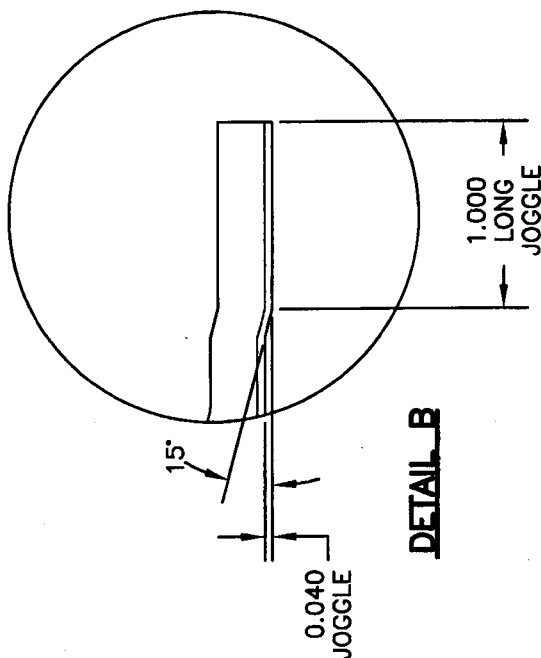
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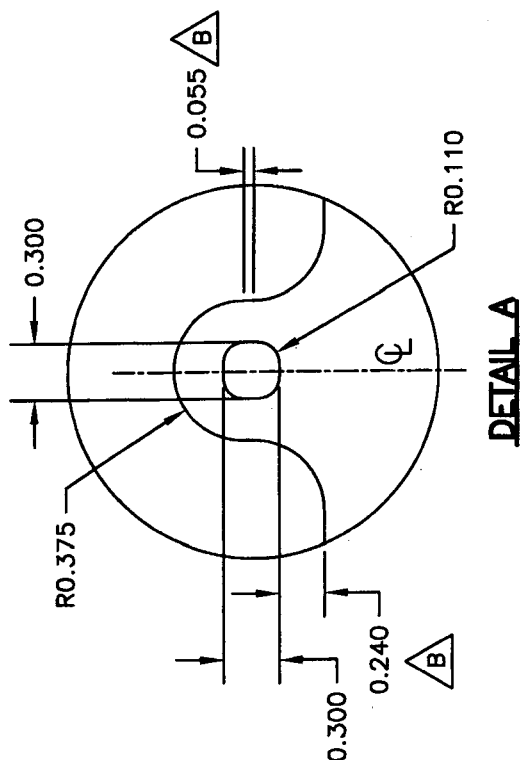


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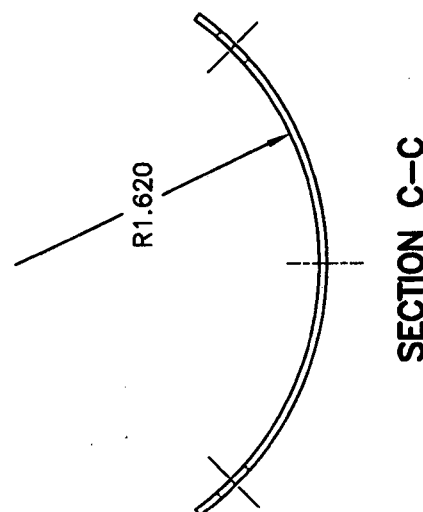
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DETAIL B



DETAIL A



SECTION C-C

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